



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4885-3
Job Sheet 187762



Part No: D4885-3

Job Qty: 4 ea

Part Name: End Fitting



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/4/19	0.00	0.00	Start Up Machining-3		
105	Doosan	4 pcs		1/4/19	0.00	4.00	Doosan		
115	CNC Vertical Machining	4 pcs		1/4/19	0.00	3.00	HAAS1-5		
117	QC	4 pcs		1/4/19	0.00	0.00	QC2 Machining-3		
120	QC	4 pcs		1/4/19	0.00	0.00	QC8 Machining-3		
130	Outsource	4 pcs		1/4/19			SKY002-VC		
140	Packaging	4 pcs		1/4/19	0.00	0.00	Packaging2		
150	QC	4 pcs		1/4/19	0.00	0.00	QC6		
160	Packaging	4 pcs		1/4/19	0.00	0.00	Packaging3-2		
170	QC21-SA	4 Ea		1/4/19	0.00	0.00	QC21		

Part Op 105 - Machine blank as per Machinist's turning detail, folio+drawing D4885-3.
Descriptions: 115 - Mill as per folio FB547. Dwg. rev: _____ Folio rev: _____
130 - ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR UTMAS PER ASTM 1417
160 - IDENTIFY AS PER QSI 044 6.1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	1.6400 ft (.41 ea)	90-Start up Operation	5 120117

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.000	2	26	0

Specifications

could not be found.

Plex 12/17/18 7:54 AM Dart.lajeunesse.marie



Container No: S144409



Part: D4885-3

Job No: 187762

Serial No/Batch: S144409

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/13/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					

DART AEROSPACE LTD		Work Order:	187762
Description: End Fitting		Part Number:	D4885-3
Inspection Dwg: D4885		Rev:	Page 1 of 1

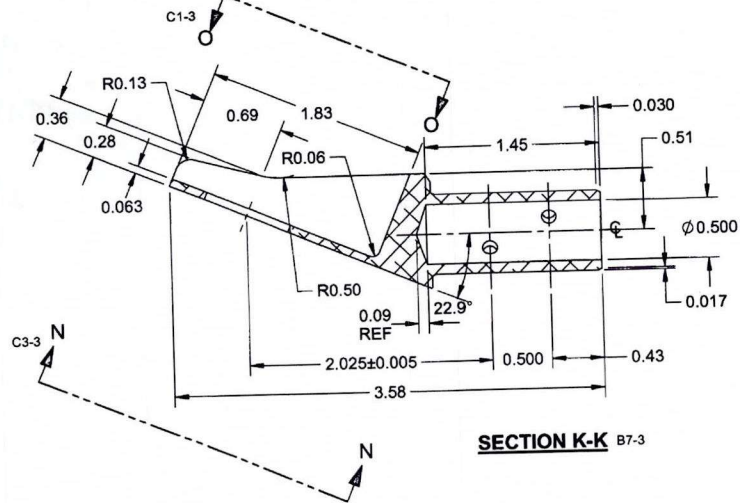
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.45	$\pm .03$	1.445			Vern LPO9	
.500	$\pm .01$	.500			↓	
.43	$\pm .03$	.431			↓	
8.500	$\pm .006 / - .001$	.500			gage pin	
.017	$\pm .01$	.017			Vern LPO9	
.030	$\pm .01$	.030			↓	
Ø.670	$\pm .006 / - .001$	.6695			Mic LPO1	
1.410	$\pm .03$	1.412			Vern LPO9	
Ø.125	$\pm .004 / - .001$	.126			gage pin	
30°	$\pm .5°$	30°			Protractor	
30°	$\pm .5°$	30°			↓	
1.83	$\pm .03$	1.828	✓		Height gauge	
R.06	$\pm .03$	.062	✓		Rad gauge	
.69	$\pm .03$	.690	✓		SL10 Vern	
R.13	$\pm .03$	.130	✓		Rad gauge	
.36	$\pm .03$	.358	✓		SL10 Vern	
.28	$\pm .03$	.280	✓		↓	
.063	$\pm .01$	.060	✓		↓	
R.50	$\pm .03$	.500	✓		Rad gauge	
2.025	$\pm .005$	2.025	✓		↓	
3.58	$\pm .030$	3.582	✓		↓	
22.9°	$\pm .5°$	22.9°	✓		Protractor	
.68	$\pm .030$	.681	✓		↓	
Ø.750	$\pm .000 / - .001$	.7495	✓		SL02 Mic	
.11	$\pm .03$	.110	✓		↓	
1.06	$\pm .03$	1.063	✓		↓	
.073	$\pm .01$	.073	✓		↓	
R.25	$\pm .03$	.250	✓		Rad gauge	

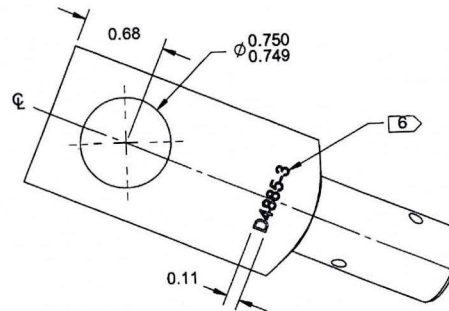
Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 19-01-13 / 19-04-10	Date: 19-04-11	Date:

Engineering Approval: (If necessary)	Date:
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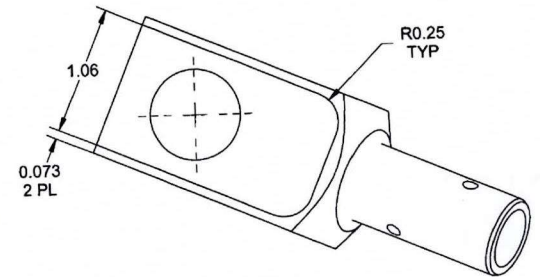
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



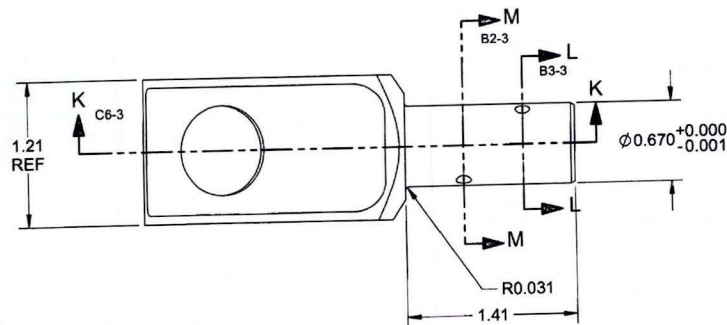
SECTION K-K B7-3



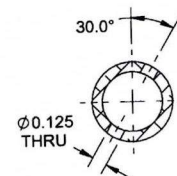
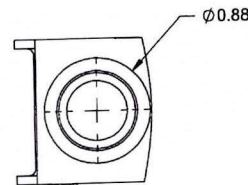
AUXILIARY VIEW N-N C8-3



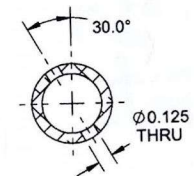
AUXILIARY VIEW O-O D7-3



D4885-3 END FITTING



SECTION L-L B6-3



SECTION M-M B6-3

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.22 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4885	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	13.12.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043224



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043224

PO Date: 4/16/19

Due Date: 4/18/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187762	D4885-3	End Fitting : Various STC's ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed - X4		4/18/19 APR 22 2019	4 pcs	0 pcs DP	4 pcs	\$156.00/pcs	\$624.00 DAS 68 9-89
Grand Total:											\$624.00

Plex 4/16/19 2:11 PM dart.lavoie.chantal



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043224



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO40083	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO043224
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 4 END FITTING P/N# D4885-3 , J/S# 187762

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						APR 18 2019	
NO CRACK FOUND							
PEN ZL-37, MPO23206, CLEANER SKC-S MPO15030, EMU. MPO23451, DEV. MPO15030, UV LIGHT M-20142							
<i>Description</i>	<i>Location</i>	<i>P/N</i>	<i>Qty</i>	<i>Batch</i>	<i>S/N Off</i>	<i>S/N On</i>	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		APR 18 2019